

**Aero Design Ltd.****Work Order Control Sheet**Work Order#: 2017-201<sup>2017</sup>Date Opened: 23 Nov 2017Title: AssemblyAircraft OEM: BellAircraft Model: 206L/407Product Type: Cargo BasketProduct Model: Low SkiQuantity: 1**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)  
 Additional Work Sheets (Standard Practice)  
 Drawings (See List Below)  
 Parts Distribution Sheet  
 Sub Component Tags  
 Completed Certification (Original)  
 Time Sheet (R&D)  
 Notes

Initial or N/A

CB/JC
N/A
CB/JC
CB/JC
N/A
JC
N/A
N/A

**Component Completion**

Quantity Complete on This Work Order  
 Quantity Incomplete on This Work Order  
 Further Processing Required Before Release  
 Release to Stock as Components

As Instructed

1
N/A
N/A
N/A

**Build Sheet Contents**

Tasks Initialled  
 Dual Inspections Initialled

Initial or N/A

CB/JC
CB/JC

**Certification**

Form One Completed  
 Serviceable (Green) Tag Completed  
 In Process (Yellow) Tag Completed  
 Unserviceable (Red) Tag Completed  
 Parts Placed in Stores for Distribution

Initial or N/A

JC
N/A
N/A
N/A
N/A

**Drawing List**

Drawing #	Rev #	Description	Initial or N/A
94610	CB - 1	Basket	CB/JC
94627	CB - 1	Placard	CB/JC
70405	4	Walkway	CB/JC
84240	0	Lid Brace Install	CB/JC
84255	2	Handle Install	CB/JC
94621	CB - 1	Brace	CB/JC

**Additional Documentation**

Documentation of a minor change  
 Non-Conformance Report Required  
 Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

**Billing**

Local (Aero Design)  
 Research and Development  
 Third Party

Initial or N/A

JC
N/A
N/A

**Traveller**

Install walkway on lid  
 Install lid on basket body  
 Re-tap mounting lug holes and install mount lugs  
 Install handle brackets  
 Install handle  
 Install lid prop  
 Install data plate

Initial or N/A

CB/JR
CB/JR
CB/JR
CB/JR
CB/JR
CB/JR
CB/JR

Work performed by:

Print: C. Brander/J. RekveSign: SCA: AD01Date: 23 Nov 2017

ICC / Dual Inspection performed by:

Print: J. ClarkeSign: SCA: AD02Date: 30 Nov 2017

Work Order closed by:

Print: C. Brander/J. ClarkeSign: SCA: AD02Date: 30 Nov 2017

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Handle Bar Assy No. of pieces: 1

Manufacturer: Aero Design

Part No.: 84261-01 Serial/Batch No.: NSN

TTSN: N/P TSO: N/A Rem.: N/A

Work Order No.: 2017 - R4

Remaining Tasks to be Performed: To be installed

Signature: [Signature]

Date: Nov 21 / 2017 Lic. No. / SCA 7304 05

Serviceable



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: 407 Low Ski Body No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 94611-01 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-06

Remaining Tasks to be Performed: See reverse.

Signature: [Signature]

Date: Oct 31 / 2017 Lic. No. / SCA 73-04

In Process



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

AMF 73-04

### Remarks

In Process

Steps: 10.

11.

12.



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: 407 Lid. No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 94612-01 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-173

Remaining Tasks to be Performed: Clean up, Inspect,  
Powder coat.

Signature: Dave Marty

Date: Oct 26/2017 Lic. No. / SCA AD 73-04 05

In Process



# **Aero Design Ltd.**

9888 A Malaspina Rd., Powell River, BC  
V8A 0G3, 604-483-AERO (2376)

Quantity: 1

PN: Tread Plate

Aircraft: All Model: N/A

Description: Lid Walkway Checker Plate

Supplier: Ryerson

Color: Aluminum

WO#: N/A

PO# 17081



# Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC  
V8A 0G3, 604-483-AERO (2376)

Quantity:	1	
PN:	MS20001P4-9600	
Aircraft:	All	
Description:	Hinge	Model: All
Supplier:	GKN Aerospace Bandy Machining	
Color:	N/A	
WO#:	N/A	

PO# 17017



## **Aero Design Ltd.**

9888 A Malaspina Rd., Powell River, BC  
V8A 0G3, 604-483-AERO (2376)

Quantity: 1

PN: 94621-01

Aircraft: Bell

Model: 407

Description: Brace

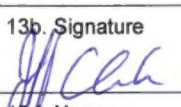
Supplier: Aero Design

Color: N/A

WO#: 2015-121

PO# N/A

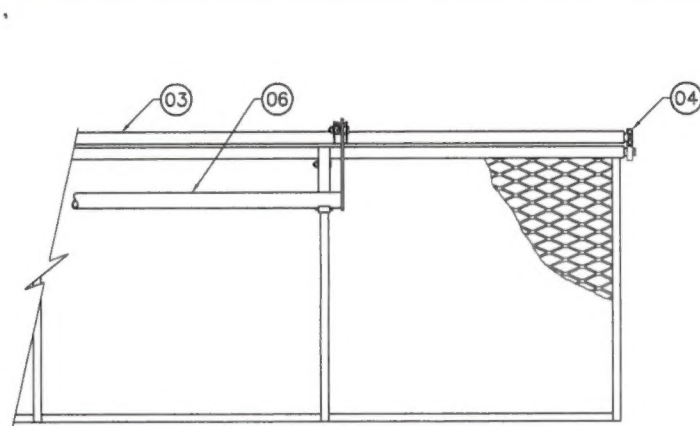


1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. AUTHORIZED RELEASE CERTIFICATE <b>FORM ONE</b>			3. Form Tracking No. <b>2017-0445</b>
4. Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>WO 2017-202</b>
6. Item <b>1.</b>	7. Description <b>Cargo Basket</b>	8. Part Number <b>94610-01</b>	9. Qty. <b>1</b>	10. Serial/Batch No. <b>94601-18</b>	11. Status/Work <b>New</b>
12. Remarks <b>Modified with Lid Walkway IAW DCL704</b>					
13a. Certifies that the items identified above were manufactured in conformity to:  <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			<del>14a. <input type="checkbox"/> CAR 571.10 Maintenance Release</del> <del><input type="checkbox"/> Other regulation specified in block 12.</del> <del>Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.</del>		
13b. Signature  <b>AD 73-04 02</b>		13c. Approved Organization Number <b>AMF 73-04</b>		<del>14b. Signature</del>	
13d. Name <b>Jeff Clarke – AD02</b>		13e. Date (dd/mmm/yyyy) <b>30 Nov 2017</b>		<del>14c. Approved Organization Number</del>	
				<del>14d. Name</del>	
				<del>14e. Date (dd/mmm/yyyy)</del>	
<b>Installer Responsibilities</b> This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.					

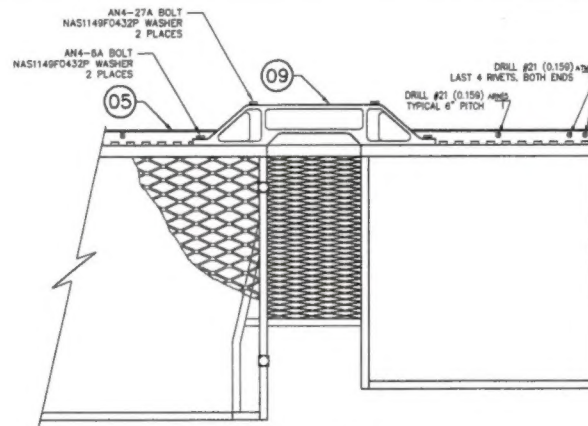
*HILLSBERO AVIATION*

3/N 94601-18

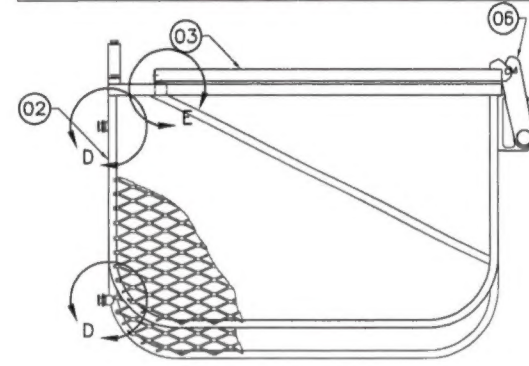
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	CREATED FROM 94511, REV. 0		
1	TITLE BLOCK UPDATED; HARDWARE UPDATED; PLACARD UPDATED	BJC	31/12/2018



VIEW A  
LOOKING AT FORWARD OUTBOARD SIDE

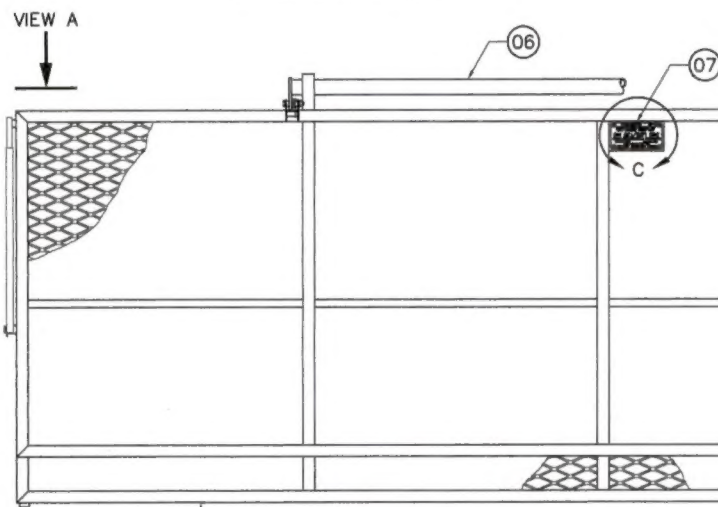


VIEW B  
LOOKING AT AFT INBOARD SIDE



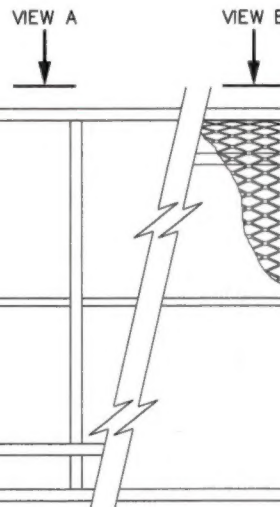
DETAIL D

SCALE 1 : 1  
LOOKING AT LOWER ATTACHMENT, UPPER ATTACHMENT SIMILAR  
TYPICAL FRONT AND REAR

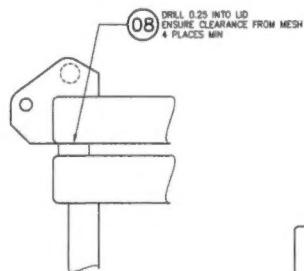


TOP VIEW

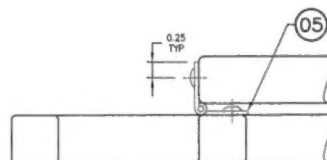
01 BASKET BODY ASSEMBLY



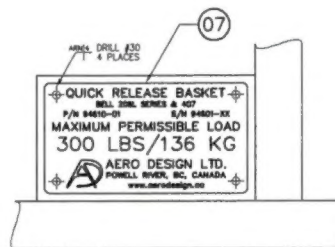
BOTTOM VIEW



BUMPER INSTALLATION  
SCALE 1 : 1



DETAIL E  
SCALE 1 : 1  
LOOKING AT HINGE



DETAIL C  
SCALE 1 : 1  
LOOKING AT PLACARD BRACKET

QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL
4	NAS1149F0432P	WASHER		
2	AN4-27A	BOLT		
2	AN4-8A	BOLT		
A/R	NAS1149F0663P	WASHER		
4	96710-01	FITTING		ALT. ANORA 4008B-14
4	CR3213-4-02	CHERRY RIVET		
8	CR3523-5-02	CHERRY RIVET		
A/R	CR3213-5-02	CHERRY RIVET		
1	94821-01	BRACE		
4	42205-14	ISUMPER		ARGUS INDUSTRIES
1	94857-01	PLACARD		
1	64235-01	HANDLE BAR INSTALLATION		
1	MS20001P4	PIANO HINGE		95 INCHES LONG
1	64240-01	BRACE INSTALLATION		
1	94812-01	LB ASSEMBLY		
1	94811-01	BASKET BODY ASSEMBLY		
1	94810-01	CARGO BASKET ASSEMBLY		

LIST OF MATERIALS

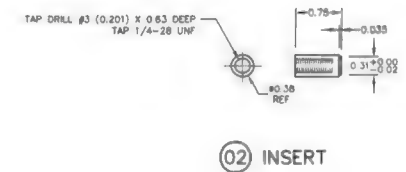
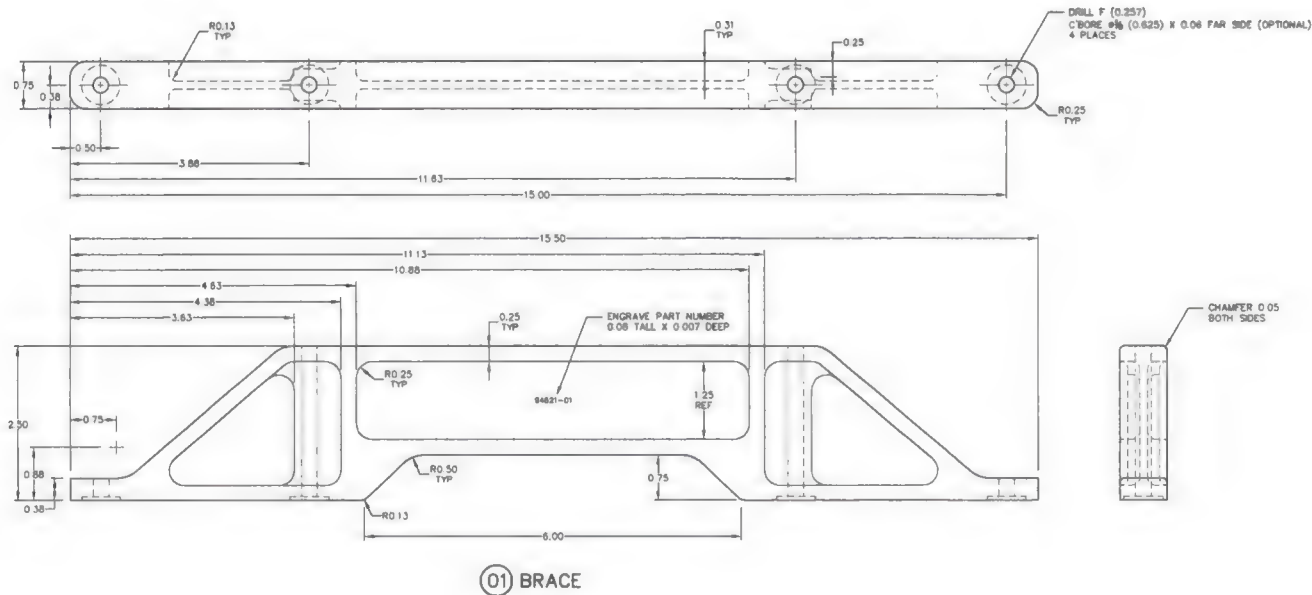
BASIC CODE	DASH NO. FOR DIAMETER	APPROVALS	DATE
REF. NAS 523	W=MFD. HEAD NEAR SIDE F=MFD. HEAD FAR SIDE	DRAWN: JEFF CLARKE	24 OCT 2011
C=COUNTERSINK	DASH NO. FOR LENGTH	CHECKED: E. BURGON	25 OCT 2011
D=DIMPLE			
DOT=# OF SHEETS TO BE DIMPLED			
BASIC CODES:			
BJ=MS20470AD	INSTALL NEW RIVET		
BB=MS20426AD	REMOVE/REPLACE RIVET		
ARH=CR3213	EXISTING RIVET		
ATM=CR3523			

SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A1	94610	1

**AERO DESIGN LTD.**  
8808A MALASPINA ROAD  
POWELL RIVER, BC, CANADA, V8A 0G3  
TEL: 854 489.3376 www.aerodesign.ca


BELL 206L SERIES, 407  
QUICK RELEASE CARGO BASKET  
CARGO BASKET ASSEMBLY

THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO AERO DESIGN LTD. WARRANTIES FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON.			
REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	TITLE BLOCK UPDATED: (01) MATERIAL UPDATED, (01) END VIEW ADDED	BJC	05/11/2016
	(01) CHAMFER ADDED, (02) SMALL DIA UPDATED, ANODIZING UPDATED		



#### NOTES

- 1 REMOVE ALL BURRS AND BREAK SHARP EDGES.
- 2 THOROUGHLY DEGREASE, ALDOINE, PRIME, AND PAINT ALL ALUMINUM PARTS PRIOR TO ASSEMBLY.  
ALTERNATE ALUMINUM PARTS TO BE ANODIZED IN ACCORDANCE WITH MIL-A-8625F, TYPE II

4	94621-02	02	INSERT	1018 MILD STEEL	AISI 1018/1020	0.375 ROD
1	94621-01	01	BRACE	8061-T6 ALUMINUM	90-A-220/8	2.5 X 0.75 BAR
PART NO		ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY			LIST OF MATERIALS			
APPROVALS				DATE		
DRAWN JEFF CLARKE				25 OCT 2011		
CHECKED E BURGIN				25 OCT 2011		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON:				 <b>AERO DESIGN LTD.</b> 8888A MALASPINA ROAD POWELL RIVER, BC, CANADA V8A 0G3 TEL. 604 682 5276 www.aerodesign.ca  BELL 206L SERIES, 407 QUICK RELEASE CARGO BASKET BRACE FABRICATION		
DECIMALS		ANGLES				
XXX ±0.010		±1/2°				
XX ±0.03						
X ±0.1						
SCALE 1:1		DWG. SIZE		DWG. NO.		REV
SHEET 1 OF 1		A1		94621		1



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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	UPDATE TITLE BLOCK; UPDATE ADDRESS AND LOGO AND P/N ADDED	BJC	04/12/2016

#### NOTES


1. ENGRAVE 0.007 DEEP AS FOLLOWS:

- "QUICK RELEASE BASKET" - 0.125 HIGH
- "BELL 206L SERIES & 407" - 0.080 HIGH
- "P/N 94610-01 S/N 94601-XX" - 0.080 HIGH
- "MAXIMUM PERMISSIBLE LOAD" - 0.125 HIGH
- "300 LBS./136 KG" - 0.200 HIGH
- "AERO DESIGN LTD." - 0.125 HIGH
- "POWELL RIVER, BC, CANADA" - 0.080 HIGH
- "www.aerodesign.ca" - 0.080 HIGH

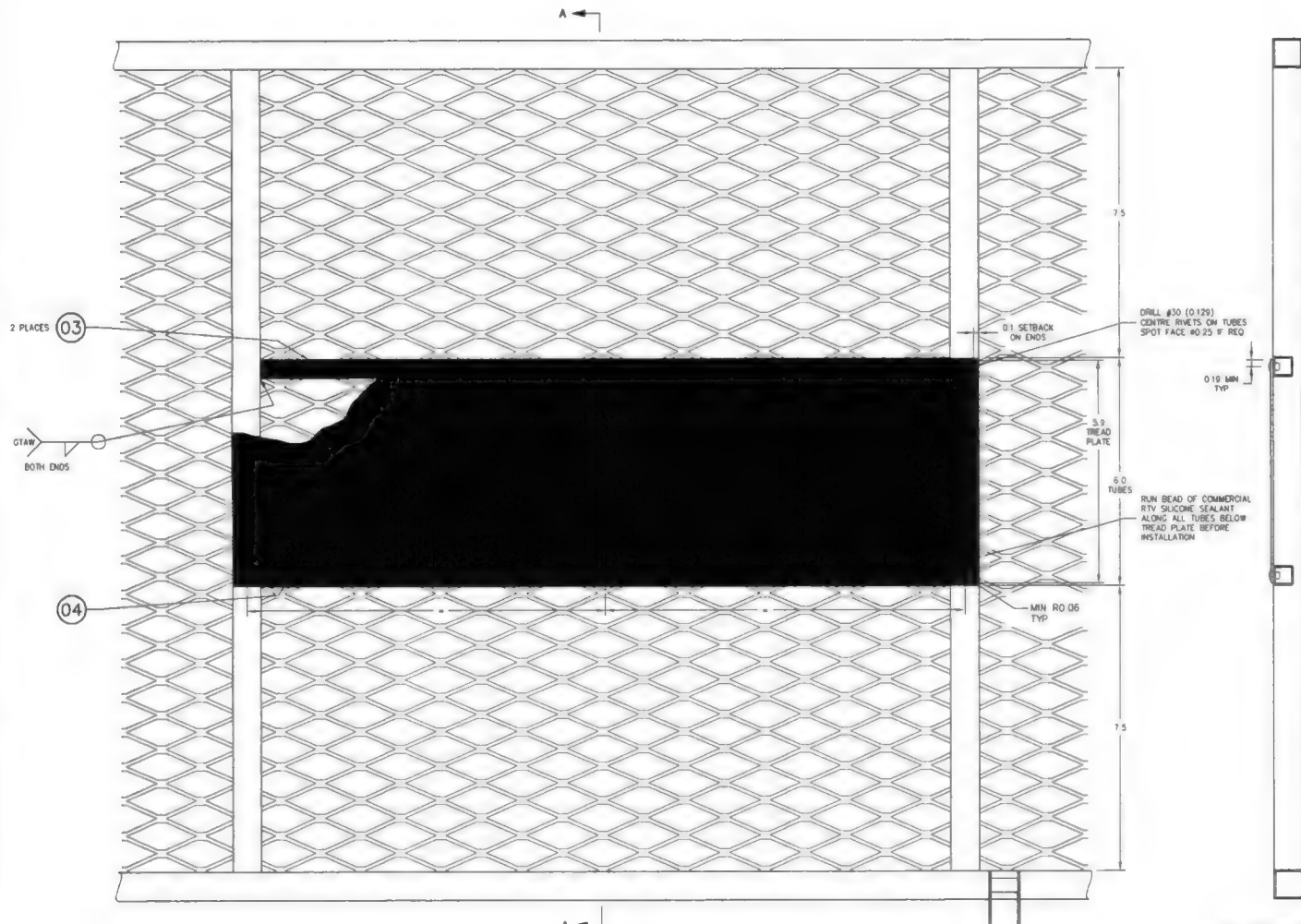
DRILL #30 (0.129)  
4 PLACES



① PLACARD

94627-01		01	PLACARD	6061-T6 ALUMINUM	QQ-A-250/11	0.050 SHEET
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					
	APPROVALS		DATE		<b>AERO DESIGN LTD.</b> 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604.483.2376      www.aerodesign.ca	
	DRAWN: JEFF CLARKE		16 SEPT 2011			
	CHECKED: E. BURGON		25 OCT 2011			
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS                      ANGLES X.XXX    ±0.010                      ±1/2" X.XX     ±0.03 X.X      ±0.1			BELL 206L SERIES, 407 QUICK RELEASE CARGO BASKET PLACARD		
				SCALE 1 : 1	DWG. SIZE	DWG. NO.
			SHEET 1 OF 1	A4	94627	1

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
1	ADD BELL MEDIUM AND EUROCOPTER AS350 BASKETS, CHANGE TUBES	BUC	MAR 19/08
2	ADD EUROCOPTER EC135, MCDONNELL DOWDAS MD500H, BELL 206B BASKETS	BUC	DEC 4/08
3	ADD NEW AS350 AND 206L/407 MODELS	BUC	DEC 4/08
4	TYPE BLOCK UPDATED, MODEL LIST REMOVED, ADD ALT RIVET, ADD NOTE 7	BUC	29/05/2014



01 BASKET LID ASSEMBLY

SECTION A-A

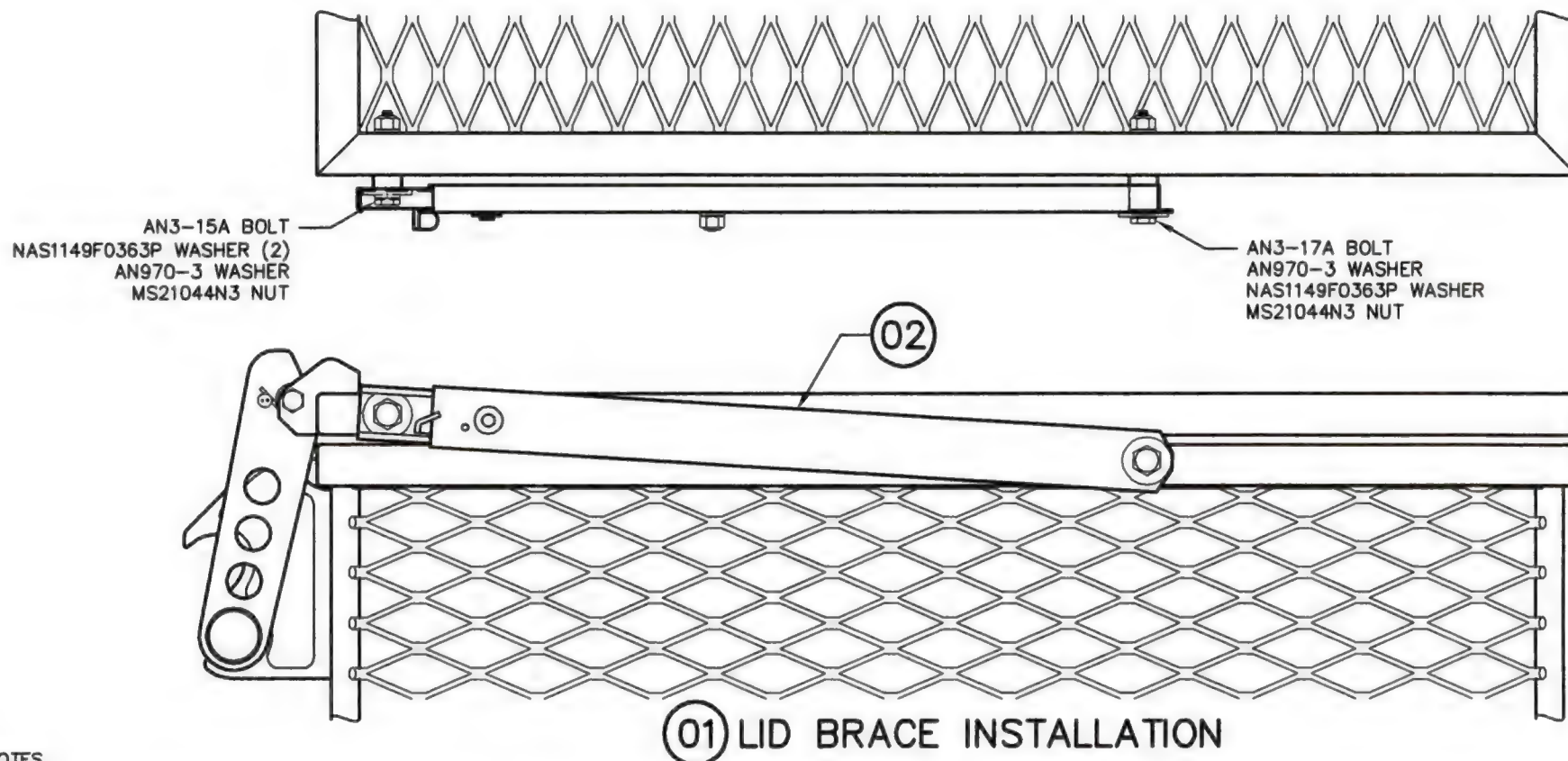
- NOTES
- 1 THIS DRAWING IS AN OPTIONAL CONFIGURATION ADDING A TREAD PLATE STEP TO THE LID. THIS CONFIGURATION MAY BE APPLIED TO ANY OR ALL BAYS OF THE LID. REMAINDER OF LID ASSEMBLY IS TO BE FABRICATED IN ACCORDANCE WITH THE APPLICABLE DRAWINGS.
  - 2 TUBES (ITEM 03) MUST BE WELDED IN PLACE BEFORE MESH IS WELDED ON BOTTOM.
  - 3 REMOVE ALL BURRS AND BREAK SHARP EDGES.
  - 4 WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2885C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
  - 5 WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
  - 6 THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY. INSTALL TREAD PLATE AFTER POWDER COATING.
  - 7 WIDTH AND POSITION OF LID STEP MAY BE ADJUSTED TO MATCH LID DOOR INSTALLED IN ACCORDANCE WITH DRAWING 70402 ON ADJOINING BAY OF THE LID.

A/R	CR3213-4-02	BLIND RIVET	ALTERNATE: HR3213-4-02		
1	70405-04	04 TREAD PLATE	ALUMINUM	COMMERCIAL	0.063 TREAD PLATE
2	70405-03	03 TUBE	4130 STEEL COND N	MIL-1-6736	0.5 X 0.035 WALL TUBE
1	SEE NOTE 1	02 BASKET LID ASSEMBLY			
	70405-01	01 BASKET LID ASSEMBLY - MODIFIED WITH STEP			
QTY	PART NO	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC
QTY					STOCK SIZE

BASIC CODE REF: HAS 523 C=COUNTERSUNK D=DIMPLE DGT=# OF SHEETS TO BE DIMPLED		DASH NO. FOR DIAMETER H=HFTD. HEAD NEAR SIDE F=HFTD. HEAD FAR SIDE DASH NO. FOR LENGTH		APPROVALS DRAWN: JEFF CLARKE 21 SEPT 2008 CHECKED: E BURGOW		DATE	
BASIC CODES: BJ = MS20470AD BB = MS20428AD ARH = CR3213 ARH = CR3212		+ INSTALL NEW RIVET + REMOVE/REPLACE RIVET - EXISTING RIVET		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS: X.XXX ±0.010 X.XX ±0.03 X.X ±0.1		AERO DESIGN LTD. 8008A MALASPINA ROAD POWELL RIVER, BC, CANADA, V0A 0G3 TEL: 804 480 3376 www.aerodesign.ca	
SCALE: 1:1 SHEET 1 OF 1				CARGO BASKET LID STEP MODIFICATION Dwg. No.: 70405 Rev: 4			

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	*	*



#### NOTES

- THIS DRAWING APPLIES TO ALL AERO DESIGN LTD. CARGO BASKET ASSEMBLIES.  
LID PROP IS TO BE INSTALLED ON THE FORWARD END OF THE BASKET AS INSTALLED ON THE HELICOPTER.

2	MS21044N3		NUT
3	NAS1149F0363P		WASHER
2	AN970-3		WASHER
1	AN3-17A		BOLT
1	AN3-15A		BOLT
1	36280-01	02	LID BRACE ASSEMBLY
	84240-01	01	LID BRACE INSTALLATION
01	PART NO.	ITEM	DESCRIPTION
QTY.	LIST OF MATERIALS		

APPROVALS	DATE
DRAWN: JEFF CLARKE	21 MAY 2014
CHECKED: JASON REKVE	21 MAY 2014

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES.  
TOLERANCES ON:  
DECIMALS ANGLES  
X.XXX  $\pm 0.010$   $\pm 1/2^\circ$   
X.XX  $\pm 0.03$   
X.X  $\pm 0.1$



**AERO DESIGN LTD.**

9886A MALASPINA ROAD  
POWELL RIVER, BC, CANADA, V8A 0G3  
TEL: 804.483.2376 www.aerodesign.ca

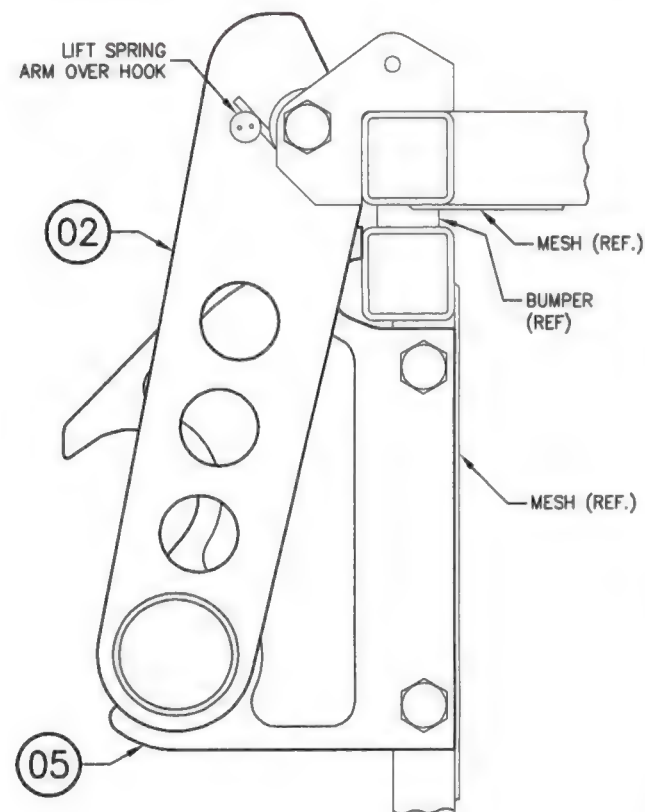
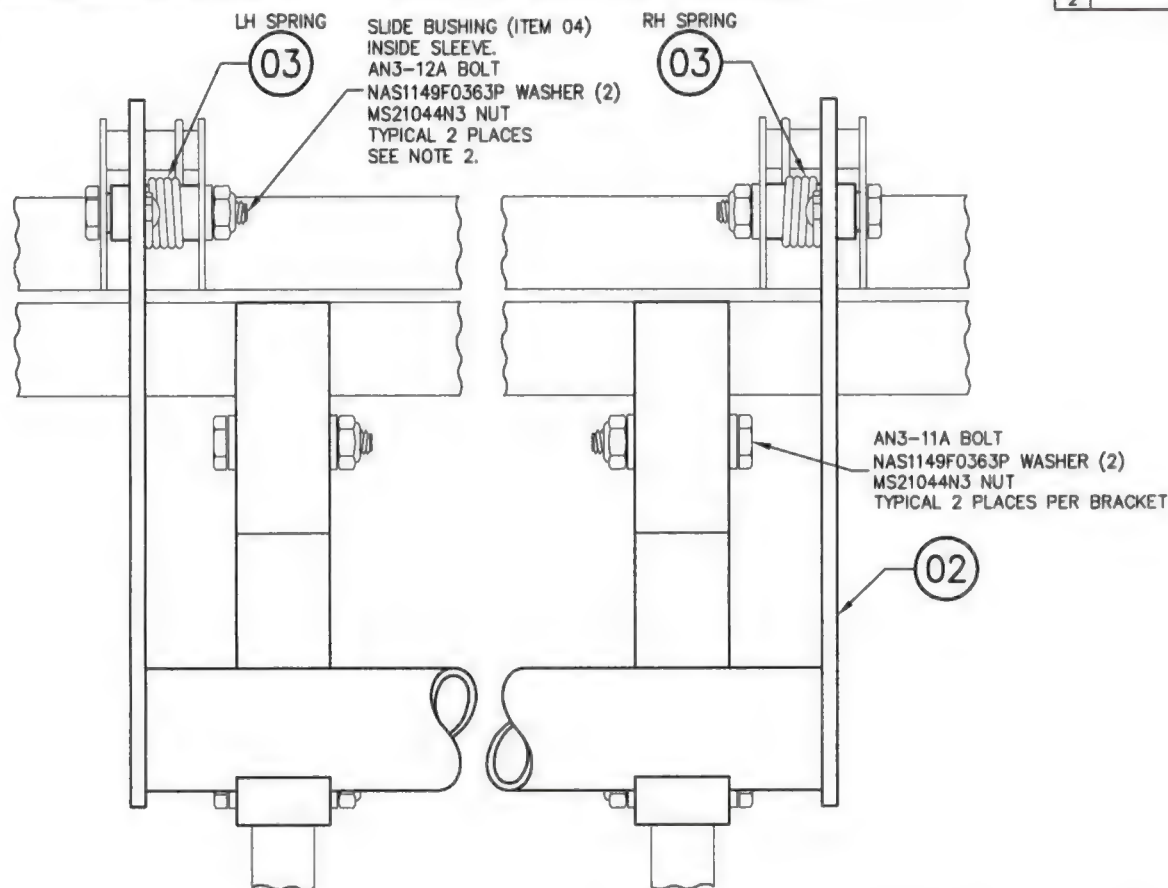
**HELICOPTER CARGO BASKET  
ALL MODELS  
LID BRACE INSTALLATION**

NOT TO SCALE	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A4	84240	0



NOTES:

1. THIS DRAWING IS AN ALTERNATE CONFIGURATION FOR THE HANDLE INSTALLATION SHOWN ON DRAWING 36255.
2. GREASE BUSHING (ITEM 04) USING MOBILGREASE 28 OR EQUIVALENT PRIOR TO INSTALLATION.



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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE - CREATED FROM 36255	BJC	NOV 03/09
1	HANDLE END BRACKETS FLIPPED	BJC	SEPT 19/11
2	TITLE BLOCK UPDATED; ADD NOTE 2; HARDWARE UPDATED	BJC	MAR 13/14

(01) HANDLE INSTALLATION

A/R	MOBILGREASE 28		GREASE	MIL-PRF-81322F
4	AN3-11A		BOLT	
2	AN3-12A		BOLT	
10	NAS1149F0363P		WASHER	
6	MS21044N3		NUT	
2	84267-01	05	BRACKET	
2	36275-01	04	BUSHING	
2	36278-01	03	SPRING (1 LH, 1 RH)	
1	84261-01	02	HANDLE BAR ASSEMBLY	
	84255-01	01	HANDLE INSTALLATION	
01	PART NO.	ITEM	DESCRIPTION	MATERIAL
QTY.	LIST OF MATERIALS			

APPROVALS	DATE
DRAWN: JEFF CLARKE	03 NOV 2009
CHECKED: E. BURGON	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:	
DECIMALS	ANGLES
X.XXX ±0.010	±1/2°
X.XX ±0.03	
X.X ±0.1	



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**HELICOPTER CARGO BASKET  
HANDLE BAR INSTALLATION**

SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A3	84255	2

Work Order: 2017-202Material Tracking Sheet  
Bell 206L / 407

1 of 2

Date Opened: 23 Nov. 2017

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>1</u>		<b>94610-01</b>	<b>Cargo Basket Assembly</b>		<b>S/N 94601-18</b>
<b>Step 1</b>				<i>Lid Assembly</i>		
	. 1		94612-01	Basket Lid Assembly		2017-173
Step 1.a.	. . 4		49205-14	Bumper	Argus Industries Bumper	See PDS
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	See PDS
Step 1.b.	. . 1		94627-01	Placard	0.063 Sheet, 6061-T6 Aluminum	2015-03
	. . 4		CR3213-4-02	Cherry Rivet		17070
Step 1.c.	. 1		70405-01	Lid Step Modification		
(option)	. . 1		70405-04	Tread Plate	3003 Aluminum Tread Plate, 0.063"	17081
	. . A/R		CR3213-4-02	Cherry Rivet		17070
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	N/A
<b>Step 2</b>				<i>Basket Assembly</i>		
Step 2.a.	. 1		94611-01	Basket Body Assembly		2017-06
	. . 4		96710-01	Fitting	Alternate: Ancra 40088-14	See PDS
	. . 8		NAS1149F0663P	Washer		See PDS
Step 2.b.	. 1		90621-01	Brace		2015-121
	. 2		AN4-6A	Bolt		15031
	. 2		AN4-30A	Bolt		15074
	. 4		NAS1149F0463P	Washer		17070
<b>Step 3</b>				<i>Hinge Installation</i>		
	. 1		MS20001P4	Piano Hinge	95"	17017
	. 8		CR3523-5-02	Cherry Rivet		15031
	. A/R		CR3213-5-02	Cherry Rivet		16053

Work Order: \_\_\_\_\_

Material Tracking Sheet  
Bell 206L / 407

2 of 2

Date Opened: \_\_\_\_\_

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
<b>Step 4</b>	. 1	84255	84255-01	Handle Installation		
Step 4.a.	.. 2		84267-01	Bracket	Delrin, 3/4" Sheet	2017-90
	.. 4		AN3-11A	Bolt		See PDS
	.. 8		NAS1149F0363P	Washer		See PDS
	.. 4		MS21044N3	Nut		See PDS
Step 4.b.	.. 1		84261-01	Handle Assembly		2017-194
	.. 2		36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	See PDS
	.. 2		36275-01	Bushing	Brass, 5/16" Dia	See PDS
	.. 2		AN3-12A	Bolt		See PDS
	.. 4		NAS1149F0363P	Washer		See PDS
	.. 2		MS21044N3	Nut		See PDS
<b>Step 5</b>				Lid Brace Installation		
	. 1		36280-01	Brace Assembly		2017-170
	. 1		AN3-15A	Bolt		See PDS
	. 1		AN3-17A	Bolt		See PDS
	. 2		AN970-3	Washer		See PDS
	. 3		NAS1149F0363P	Washer		See PDS
	. 2		MS21044N3	Nut		See PDS
<b>Step 6</b>				Inspection	None	



WO# 2017-202

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013



## CARGO BASKET ASSEMBLY - COMMON

Work Order: 2017-202

Date Open: 23 Nov. 2017

### General

These instructions apply to all cargo basket assemblies. Refer to the following drawings, at the current revision, for dimensions and details. Drawings are linked to the source for ease of printing.

✓	Basket Type	Basket			Lid Walk	Lid Prop	Handle		
		Ass'y	Placard	Mat'l			Inst'n	Ass'y	Mat'l
Bell 206B – right side only									
	Short	<a href="#">80210</a>	<a href="#">80227</a>	<a href="#">Mat'l</a>	<a href="#">70405</a>	<a href="#">84240</a>	<a href="#">84255</a>	<a href="#">84261</a>	<a href="#">Mat'l</a>
	Medium	<a href="#">80310</a>	<a href="#">80327</a>	<a href="#">Mat'l</a>					<a href="#">Mat'l</a>
	Long	<a href="#">81110</a>	<a href="#">81127</a>	<a href="#">Mat'l</a>					<a href="#">Mat'l</a>
Bell 206L/407 – Right side only									
	Low Standard	<a href="#">69810</a>	<a href="#">69827</a>	<a href="#">Mat'l</a>	<a href="#">70405</a>	<a href="#">84240</a>	<a href="#">84255</a>	<a href="#">84261</a>	<a href="#">Mat'l</a>
	Low Wide	<a href="#">94510</a>	<a href="#">94527</a>	<a href="#">Mat'l</a>					<a href="#">Mat'l</a>
	Low Ski	<a href="#">94610</a>	<a href="#">94627</a>	<a href="#">Mat'l</a>					<a href="#">Mat'l</a>
	High Ski	<a href="#">76610</a>	<a href="#">76625</a>	<a href="#">Mat'l</a>					<a href="#">Mat'l</a>
Bell Medium – left or right									
	Standard	<a href="#">75110</a>	<a href="#">75127</a>	<a href="#">Mat'l</a>	<a href="#">70405</a>	<a href="#">84240</a>	<a href="#">84255</a>	<a href="#">84261</a>	<a href="#">Mat'l</a>
	Extra Large (ski)	<a href="#">95510</a>	<a href="#">95527</a>	<a href="#">Mat'l</a>					<a href="#">Mat'l</a>
	Mega	<a href="#">100610</a>	<a href="#">100627</a>	<a href="#">Mat'l</a>					<a href="#">Mat'l</a>
Bell 429 – right or left									
	Standard – Pre S/N 71	<a href="#">95910</a>	<a href="#">95927</a>	<a href="#">Mat'l</a>	<a href="#">70405</a>	<a href="#">84240</a>	<a href="#">84255</a>	<a href="#">84261</a>	<a href="#">Mat'l</a>
	Standard – Post S/N 71	<a href="#">95950</a>	<a href="#">95927</a>	<a href="#">Mat'l</a>					<a href="#">Mat'l</a>
Eurocopter AS350/AS355 – left or right									
	Short	<a href="#">77610</a>	<a href="#">77627</a>	<a href="#">Mat'l</a>	<a href="#">70405</a>	<a href="#">84240</a>	<a href="#">84255</a>	<a href="#">84261</a>	<a href="#">Mat'l</a>
	Medium	<a href="#">76410</a>	<a href="#">76427</a>	<a href="#">Mat'l</a>					<a href="#">Mat'l</a>
	Long	<a href="#">78410</a>	<a href="#">78427</a>	<a href="#">Mat'l</a>					<a href="#">Mat'l</a>
	Ski	<a href="#">94010</a>	<a href="#">94027</a>	<a href="#">Mat'l</a>					<a href="#">Mat'l</a>
Robinson R44 – left or right									
	Standard	<a href="#">90610</a>	<a href="#">90627</a>	<a href="#">Mat'l</a>	<a href="#">70405</a>	<a href="#">84240</a>	<a href="#">84255</a>	<a href="#">84261</a>	<a href="#">Mat'l</a>
MD600									
	Standard	<a href="#">82810</a>	<a href="#">82827</a>	<a href="#">Mat'l</a>	<a href="#">70405</a>	<a href="#">84240</a>	<a href="#">84255</a>	<a href="#">84261</a>	<a href="#">Mat'l</a>

Hyperlinking to specific excel sheet –

1. on desired excel sheet cell A1, set name of cell, eg. Assembly.
2. at end of hyperlink add #Assembly (filename.xls#Assembly).

CB OK

## 1. Lid Assembly

## a. Install lid bumpers on bottom.

- i. Drill  $\frac{1}{4}$ " holes using center drill, 3 (standard/medium) or 4 (long/ski) places.
- ii. Fill bumper holes with RTV silicone sealant.
- iii. Insert 49205-14 lid bumper, 3 or 4 places per lid.

## b. Install placard on bracket on top of lid

Note: 959 and 1006 placard is installed on body.

- i. Locate placard on bracket.
- ii. Drill #30 through placard and bracket, using holes in placard.
- iii. Remove placard and de-burr holes in placard and on bracket.
- iv. Locate placard on bracket, and cleco in place.
- v. Rivet placard with four CR3213-4-02 CherryMax rivets.

## c. Option: Install walkway on top of lid (lid must be fitted with walkway provisions)

- i. Note: avoid touching surface of tread plate with bare hands to prevent smudges or marks on the top surface.
- ii. Pull tread plate from stock. Shear tread plate to length.
- iii. De-burr edges of tread plate with scotch-brite wheel on bench grinder.
- iv. Locate tread plate on lid. Hold tread plate in place with bags of lead shot.
- v. Mark and drill #30 holes:
  1. 0.25" from edge of tread plate, centre on cross members (0.38")
  2. 0.25" from edge of tread plate, middle of each walkway stringer
- vi. De-burr and counter-bore (if required to provide clearance of rivet head on checker pattern) all holes in tread plate using  $\frac{1}{4}$ " piloted counter bore on both sides.
- vii. De-burr holes in lid tubes.
- viii. Apply bead of RTV silicone sealant along all tubes under tread plate.
- ix. Set tread plate in place, secure with clecos if necessary.
- x. Rivet placard with CR3213-4-02 CherryMax rivets

## d. Record PO/WO of all parts (including lid) used in steps above on attached material tracking list.

CB OK

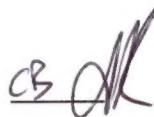
## 2. Body Assembly

## a. Install attachment fittings

- i. Carefully remove excess powder coat from around attachment lug threads using a countersink.
- ii. Run 3/8-24 tap into attachment lugs to clear threads.
- iii. Apply anti-seize compound to attachment fittings 96710-01 (alternate: Ancra 40088-14)
- iv. Install attachment fittings with two NAS1149F0363P washers in four lugs in basket.
  1. 90610 (Robinson R44) basket only:
    - a. Install 1 fitting 90628-01 in lower forward attachment lug only.
    - b. Install 3 96710-01 fittings in remaining locations.
- v. Torque to 160-190 in-lbs (13.3-15.8 ft-lbs).



- b. 959 and 1006 Baskets only: Install inboard sheet on upper rim of basket
  - i. Locate sheet on basket.
  - ii. Drill #30 through sheet and rim, located as specified on drawing. Cleco in place.
  - iii. Remove sheet and de-burr holes in sheet and rim.
  - iv. Apply bead of RTV silicone sealant along all tubes under sheet.
  - v. Locate sheet on basket, and cleco in place.
  - vi. Rivet sheet with CR3213-4-02 CherryMax rivets.
- c. 959 Basket only: Install forward sheet
  - i. Locate sheet on basket. Ensure sufficient clamps are in place.
  - ii. Drill #30 through sheet, rim and hoop, located as specified on drawing. Cleco in place.
  - iii. Remove sheet and de-burr holes in sheet and rim.
  - iv. Apply bead of Pro-Seal sealant along all tubes under sheet.
  - v. Locate sheet on basket, and cleco in place.
  - vi. Rivet sheet with CR3213-4-02 CherryMax rivets.
- d. Record PO/WO of all parts (including basket) used in steps above on attached material tracking list.



### 3. Hinge Installation

- a. Prepare hinge.
  - i. Cut hinge to length:
    - 1. 776, 906 – 54"
    - 2. 751, 803 – 70"
    - 3. 698, 764, 945 – 72"
    - 4. 766, 784 – 90"
    - 5. 940, 946, 959 – 95"
    - 6. 1006 – 107"
  - ii. Drill #30 pilot holes using hinge jig. For long hinges, flip at specified location on jig.
- b. Install hinge on basket
  - i. Locate hinge on basket (standard baskets)
    - 1. centre fore/aft
    - 2. 0.15" – 0.18" up from bottom edge
  - ii. Locate hinge on basket (extra wide baskets)
    - 1. centre fore/aft
    - 2. set hinge at 90 degrees (as if lid would be installed) using a small square, locate vertical side at 22.5" from outboard edge.
  - iii. Drill #30 through holes in hinge into basket rim. Cleco in place with 1/8 (copper) clecos.
  - iv. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 (black) clecos.
  - v. Remove hinge and de-burr holes in hinge and basket rim.
  - vi. Cleco hinge to basket with 5/32 clecos.
  - vii. Install hinge with CherryMax rivets
    - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
    - 2. CR3213-5-02 aluminum rivets – all other locations

- c. Install lid on basket
  - i. Locate lid on hinge (all baskets)
    - 1. center fore/aft
    - 2. 0.15" – 0.18" down from top edge
  - ii. Drill #30 through holes in hinge into lid rim. Cleco in place with 1/8 clecos.
  - iii. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 clecos.
  - iv. Remove hinge and de-burr holes in hinge and lid rim.
  - v. Cleco lid to hinge with 5/32 clecos.
  - vi. Install hinge with CherryMax rivets
    - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
    - 2. CR3213-5-02 aluminum rivets – all other locations
- d. Record PO of hinge and rivets on attached material tracking list.

#### 4. Install Handle

- a. Install handle brackets.
  - i. Set 84267-01 handle bracket on provisions in hoops, 2 places.
  - ii. Install AN3-11A bolt, NAS1149F0363P washer (2), MS21044N3 nut. Two places per bracket, two brackets per basket.
  - iii. Torque AN3 bolts to 20-25 in-lbs.
- b. Install handle
  - i. Trim 36278-01R and 36278-01L springs to ensure end of spring does not extend past edge of handle bracket, approximately 1/8". Set springs over bushing of 84261-01 handle assembly.
  - ii. Grease two 36275-01 bushings with Mobil Grease 28 or equivalent. Insert into bushings of handle assembly.
  - iii. Locate handle on basket lid. Insert AN3-12A bolt with NAS1149F0363P through bracket on lid and handle bushing on one end of handle.
  - iv. On other end of handle, hook spring over catch rivet on handle assembly and use spring tool to twist spring to catch arm on bracket on lid while inserting AN3-12A bolt with NAS1149F0363P washer through lid bracket and handle bushing.
  - v. At first end, remove bolt and repeat step iv.
  - vi. Install NAS1149F0363P washer and MS21044N3 nut on both AN3-12A bolts.
  - vii. Torque AN3 bolts to 20-25 in-lbs.
- c. Check handle
  - i. Operate handle to ensure handle does not bind and springs hold handle in.
  - ii. Snap handle into brackets to ensure handle locks.
- d. Record PO/WO of all parts used in steps above on attached material tracking list.



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## 5. Install lid brace

- a. Locate 36280-01 lid brace on bushing in basket. Ensure brace is on forward end of basket as it will be installed on the helicopter.
- b. On lid end, insert AN970-3 washer into end of lid brace. Insert AN3-15A bolt with NAS1149F0363P washer through AN970-3 washer, lid prop, and lid bushing. Install NAS1149F0363P washer and MS21044N3 nut on bolt.
- c. On basket end, insert AN3-17A bolt with AN970-3 washer through lid prop and basket bushing. Install NAS1149F0363P washer and MS2144N3 nut on bolt.
- d. Ensure brace is seated on lip of bushings before tightening nuts.
- e. Torque AN3 bolts to 20-25 in-lbs.
- f. Record PO/WO of all parts used in steps above on attached material tracking list.

## 6. 946 Basket Only: Install Cutout Brace

- a. Locate 94621-01 Brace over aft cross tube cutout.
- b. Install two AN4-6A bolts and two AN4-27A bolts with NAS1149F0463P washers.
- c. Torque AN4 bolts to 50-70 in-lbs.

## 7. Final Inspection

Dual inspection by a different person than assembled the basket.

- a. Check for general condition and correct assembly:
  - i. Bolts are tight
  - ii. Rivets are installed correctly
  - iii. Handle operates correctly
  - iv. Lid brace operates correctly
- b. Check that PO/WO numbers have been recorded.

CB OK

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